

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027064**Date Inspected:** 23-Jan-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Watson Bowman Acme**Location:** Amherst NY**CWI Name:** Reno Davis**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Channel Assemblies SEI112667CA2**Summary of Items Observed:**

This (QAI) arrived at Watson Bowman Acme, Amherst NY, as requested to monitor progress on fabrication of the Channel Assemblies SEI112667CA2. This QAI met with John Miller, QC Watson Bowman Acme (WBA), and Mr. Reno Davis QC, to discuss progress and any changes in schedule.

Upon arrival at Watson Bowman this QAI found WBA welder Jason Gray laying out the locations for the 22mm x 100mm Concrete Anchor Studs on Channel Assemblies SEI112667CA2-23 and 24. There are (4) studs welded to the CA2-23 Channel Assembly already and WBA is waiting for delivery of the (44) remaining anchor studs needed to complete the last (2) remaining channel assemblies. Locations were prick punched and ground smooth for stud welding.

New shipment of anchor studs received UPS at WBA. Studs received from Tru-Fit Products Medina Ohio. MTR received from John Miller verify Heat Number on studs is 10154070 and material meets ASTM-A108-07/A29 specifications and certified "melted and manufactured in the U.S.A."

This QAI then witnessed Watson Bowman welder John Ash begin welding the studs to Channel Assembly SEI112667CA2-23. Mr. Davis was present to verify welding was being performed per approved WPS. After (5) studs there was a misfire with the stud gun. The stud broke off the channel plate. Area will be ground flush, MT inspected and a new stud welded in place.

The items observed appear to be progressing as scheduled and are in general conformance with the contract documents.

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Summary of Conversations:

Basic conversation, fundamental to completion of the tasks at hand, occurred between this QAI, ABF QC and WBA Personnel.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 858-531-0335, who represents the Office of Structural Materials for your project.

Inspected By: Sullivan, Kevin

Quality Assurance Inspector

Reviewed By: Foerder, Mike

QA Reviewer